

Date: Monday, 12/01/2009 9:12:21 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : INBOARD WINDOW DOUBLER  
 Job Number : 44599  
 Estimate Number : 13147  
 P.O. Number :  
 This Issue : 12/01/2009 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL / MED FAB  
 Previous Run : 38828  
 Part Number : D37001  
 Drawing Number : D3700 PRELIM  
 Project Number : N/A  
 Drawing Revision : PRELIM  
 Material :  
 Due Date : 15/01/2009 Qty: 5 Um: Each  
 Written By : U  
 Checked & Approved By : U  
 Comment : Est Rev:A 08-01-30 new issue DD verified by:EC



## Additional Product

**PRELIMINARY ISSUE**

Job Number:



509.0.12 Per DWG #04502P

Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.2984 sf(s)/Unit Total: 1.4921 sf(s)  
 6061T6 aluminium sheet .080" thick  
 (M6061T6S080)  
 Batch: 110254 IB 9-1-13

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3700  
 Dwg Rev: PRE IB 9-1-13  
 Prog Rev: Lim

2- Deburr if necessary IB 9-1-13

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

**ENGINEERING APPROVAL**

509.0.15 (5)



IB 9-01-13

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

509.0.14

5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

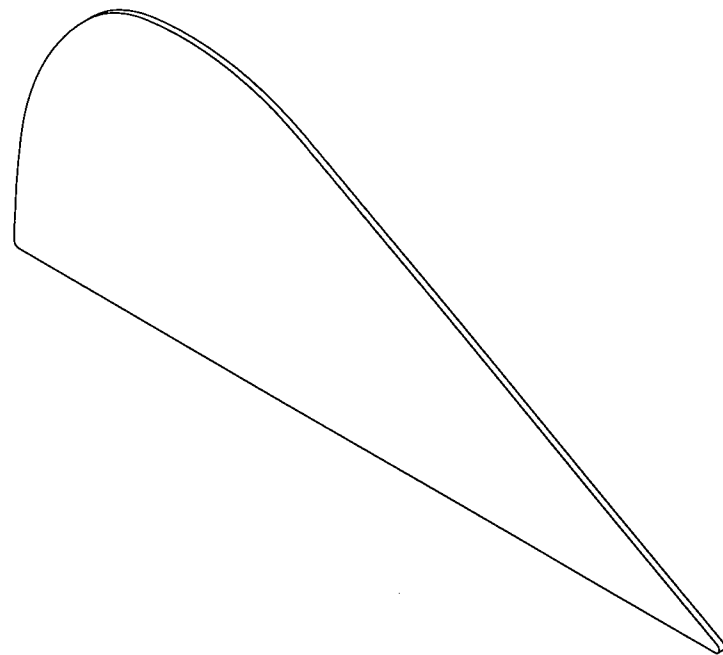
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

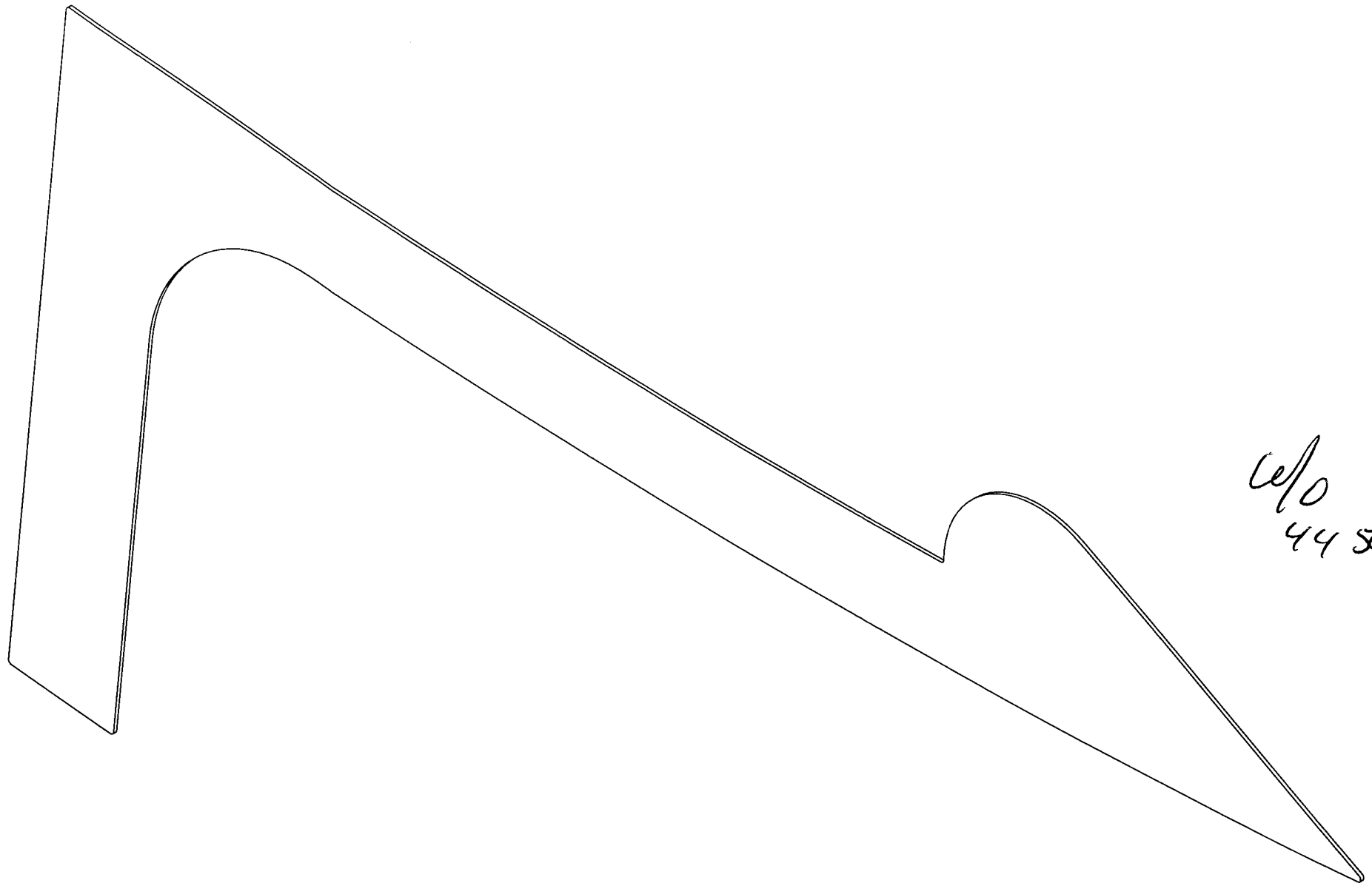


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D3700-1 INBOARD WINDOW DOUBLER

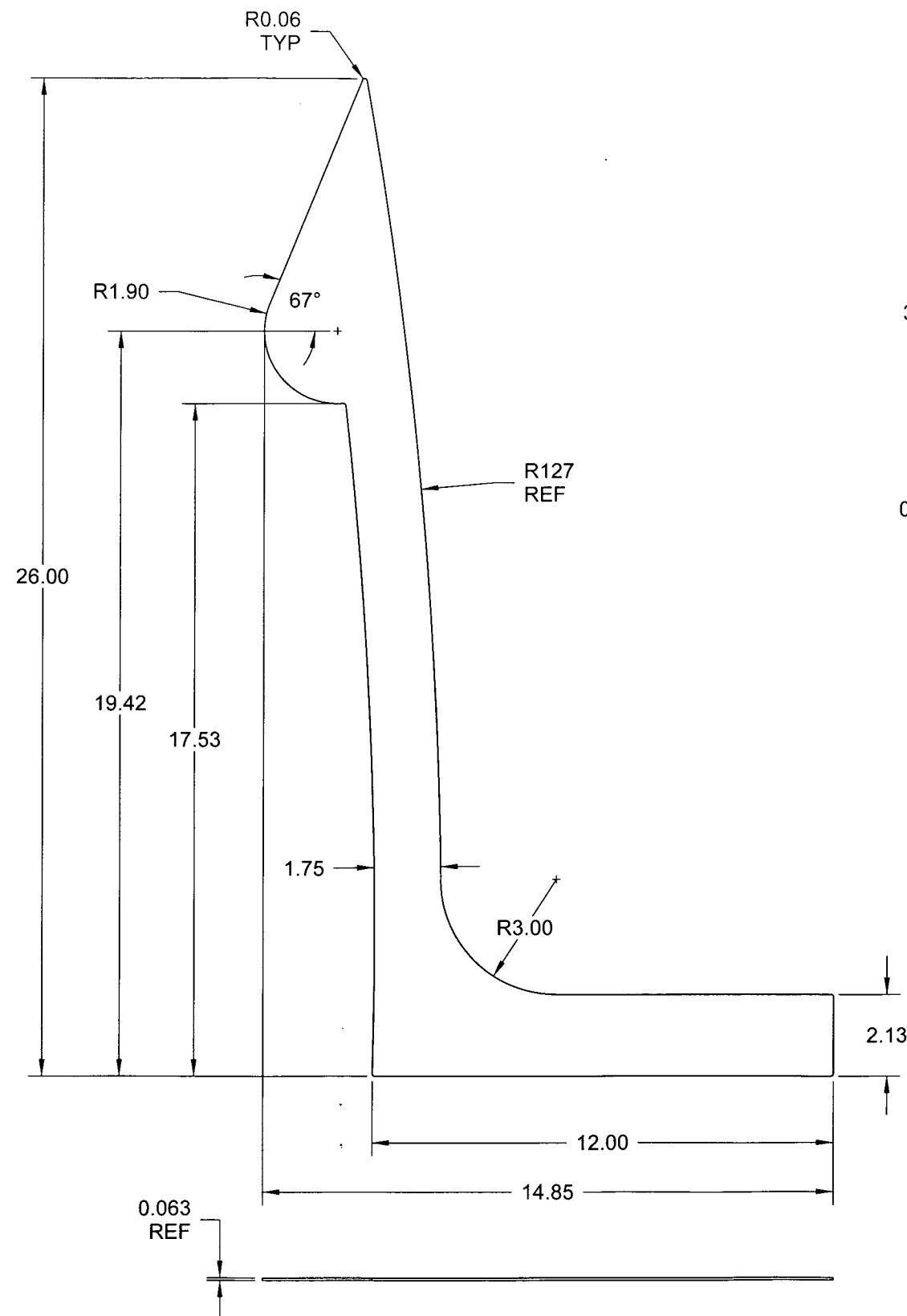


D3700-3 OUTBOARD WINDOW DOUBLER

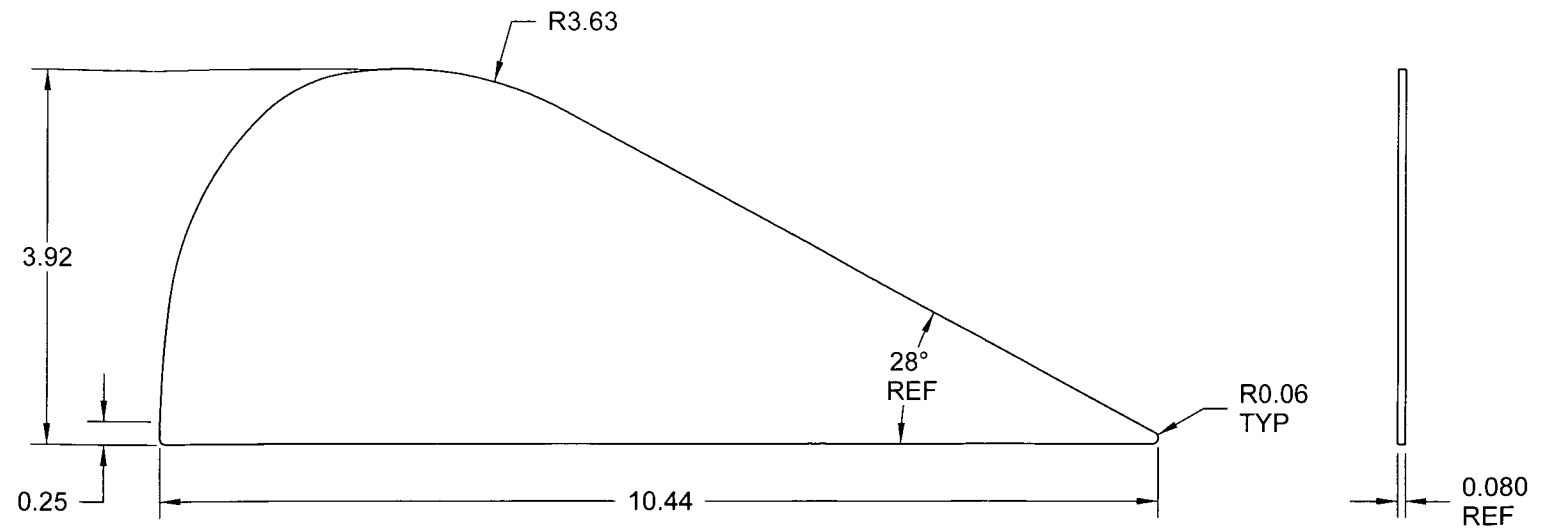
W/O  
44 529

PRELIMINARY ISSUE  
D 09.01.12  
PER ECN #09.5020

A	NEW ISSUE		MB	08.01.29
REV.	DESCRIPTION		BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3700	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		WINDOW DOUBLER	NTS	
DATE	08.01.29		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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9 D3700-3 OUTBOARD WINDOW DOUBLER



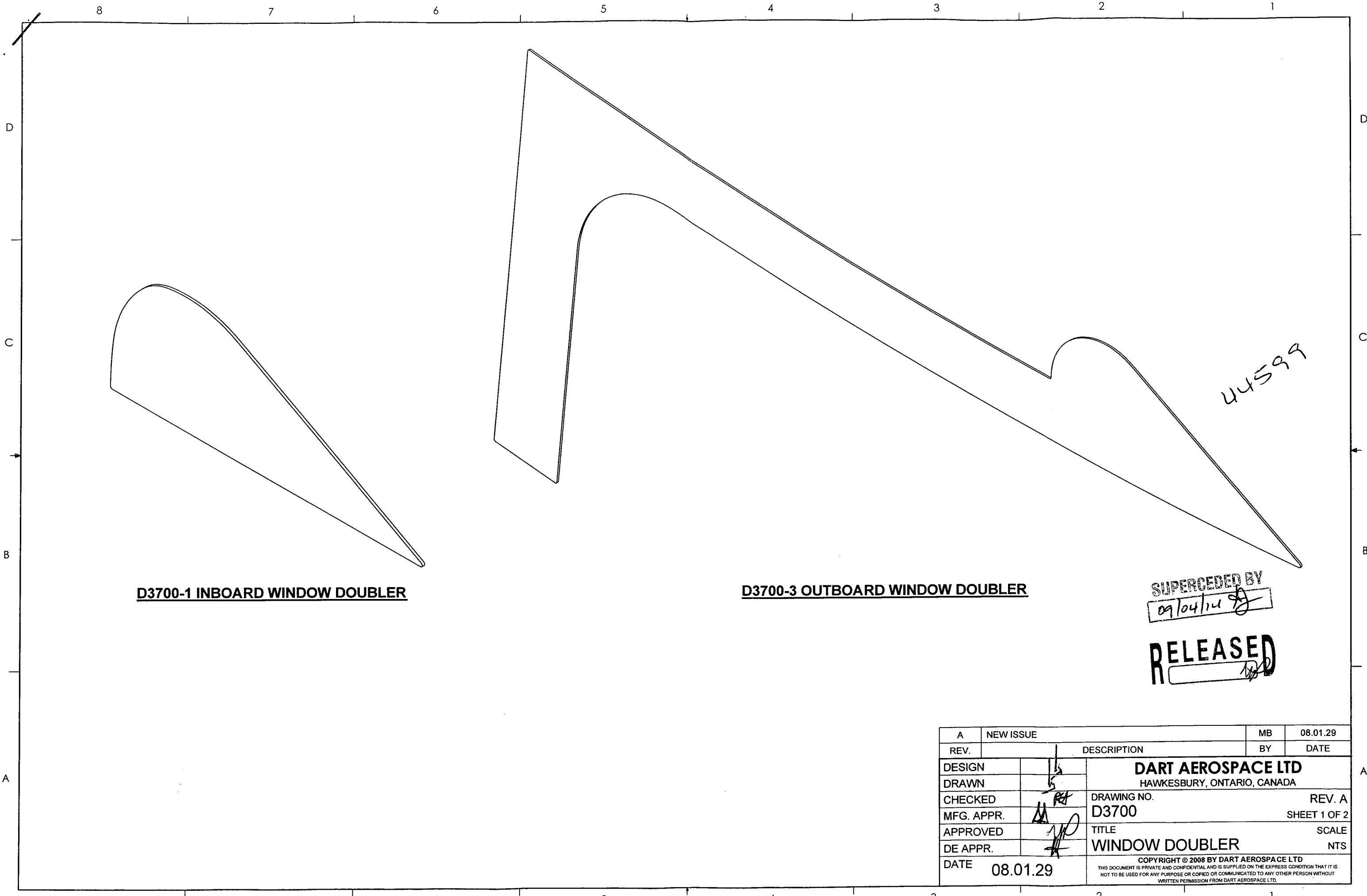
8 D3700-1 INBOARD WINDOW DOUBLER

44549  
PRELIMINARY ISSUE  
10/01/12 Rev  
ECN #01,502P

NOTES:

- 1) MATERIAL:  
D3700-1: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.080)  
D3700-3: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3700-X" USING FINE  
POINT PERMANENT INK MARKER
- 7) WEIGHT: D3700-1 = 0.20 lbs  
D3700-3 = 0.45 lbs
- 8) MANUFACTURE PART FROM "D3700-1.DXF" FILE
- 9) MANUFACTURE PART FROM "D3700-3.DXF" FILE

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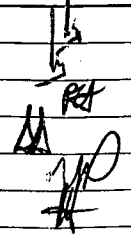
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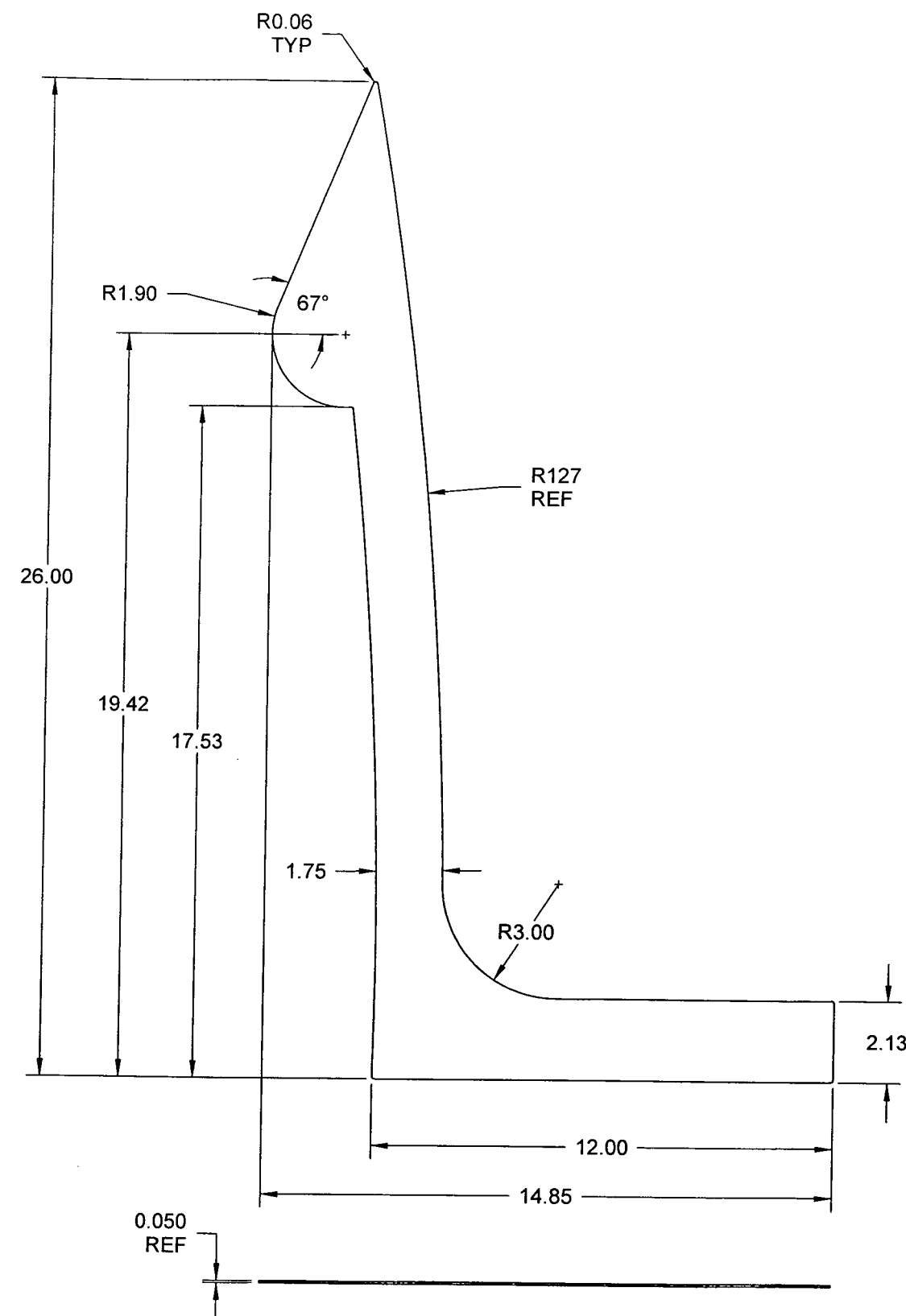
D3700-3 OUTBOARD WINDOW DOUBLER

44599

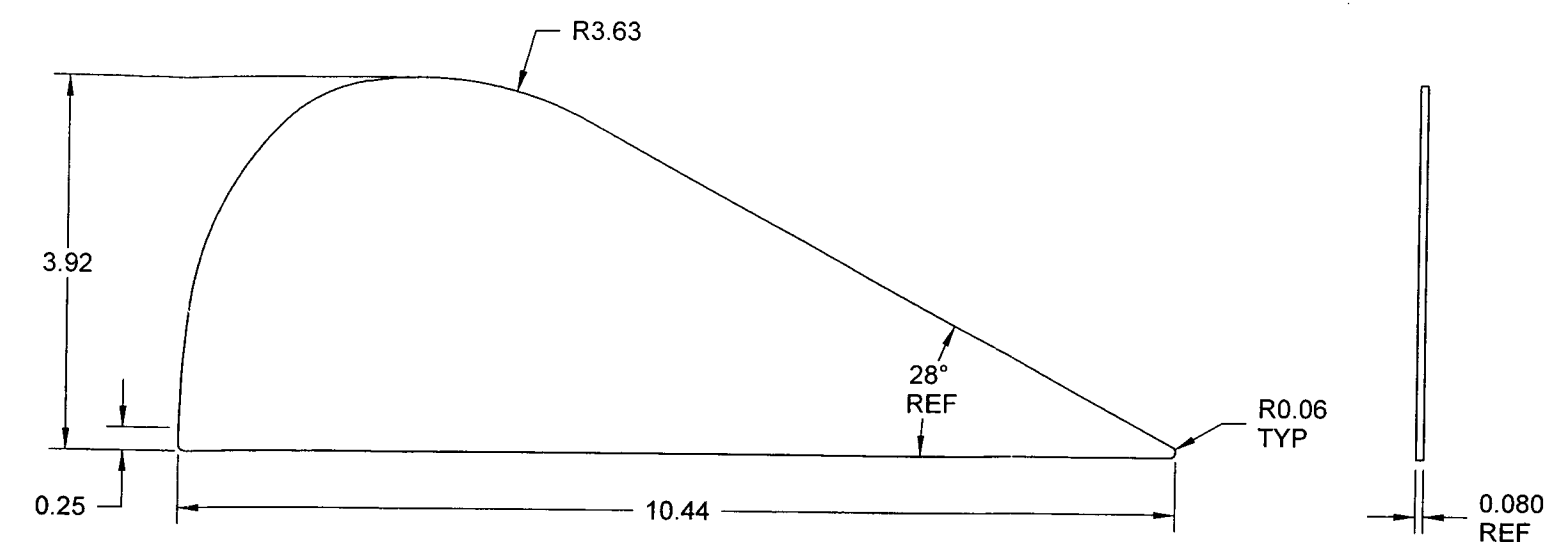
SUPERCEDED BY  
09/04/14

RELEASED

A	NEW ISSUE		MB	08.01.29
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9 D3700-3 OUTBOARD WINDOW DOUBLER



8 D3700-1 INBOARD WINDOW DOUBLER

- NOTES:
- 1) MATERIAL:  
D3700-1: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.080)  
D3700-3: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3700-X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: D3700-1 = 0.20 lbs  
D3700-3 = 0.36 lbs
  - 8) MANUFACTURE PART FROM "D3700-1.DXF" FILE
  - 9) MANUFACTURE PART FROM "D3700-3.DXF" FILE

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RELEASED

44599

**D3700-1 INBOARD WINDOW DOUBLER**

**D3700-3 OUTBOARD WINDOW DOUBLER**

**RELEASED**  
09/03/18

44599

REV.	DESCRIPTION	BY	DATE
B	ADDED 0.25" TO TOP PROFILE OF D3700-1 (ZN D8-2); REDIMENSION PARTS; REMOVED REFERENCES TO DXF FILES (NOTES 8 AND 9).	MB	09.03.18
A	NEW ISSUE	MB	08.01.29
DESIGN	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3700</b> TITLE <b>WINDOW DOUBLER</b> SCALE <b>NTS</b> COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>		
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APPROVED			
DE APPR.			
DATE	09.03.18		



